

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021553**Date Inspected:** 05-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Peng wen jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as W2-SB19-001-94, located on OBG frame, W2-SB19-001, welder is identified as 201888, ZPMC Quality Control (QC) is identified as Mr. Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132(2F)-ESAB.

SMAW welding of weld identified as E5-SB24-001-081, located on OBG frame, E5-SB35-001, welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr.Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

SMAW welding of weld identified as E5-SB28-001-050, located on Steel Barrier, E5-SB28-001.Welder is identified as 201888, ZPMC Quality Control (QC) is identified as Mr.Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2131-ESAB.

SMAW welding of weld identified as E5-SB22-001-126, located on Steel Barrier, E5-SB22-001.Welder is identified as 048625, ZPMC Quality Control (QC) is identified as Mr.Peng wen jun. The welding variables

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recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

SMAW welding of weld identified as E5-SB23-001-124, located on Steel Barrier, E5-SB23-001. Welder is identified as 222396, ZPMC Quality Control (QC) is identified as Mr. Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W2-SB15-001-012, located on Steel Barrier, W2-SB15-001. Welder is identified as 201905, ZPMC Quality Control (QC) is identified as Mr. Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB(3F).

FCAW welding of weld identified as W2-SB13-002-52, located on Steel Barrier, W2-SB13-002. Welder is identified as 053753, ZPMC Quality Control (QC) is identified as Mr. Peng wen jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

OBG Bay # 10

NDT

The following NDT performed ZPMC NDT notification 08462:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 15:00 hours. The members are identified as follows OBG, Bike Path, The weld designations reviewed are as follow: BK014A1-001-009.

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 15:00 hours. The members are identified as follows OBG, Bike Path, The weld designations reviewed are as follow: SSD1-FESA6-1-11, 12, NSD1-FESA6-3-12, 13.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert
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Quality Assurance Inspector

Reviewed By:	Hall, Steven
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QA Reviewer
